

Work Order ID 140867

January 21, 2016 11:06:03 AM

140867

Page 1

Needs to ship Jan 29th.

Item ID: D4888-041L02 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dome Light Air Vent Assembly, Black
 Start Date: 1/21/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/29/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SK 20160121 Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4888	A								
100		0.00							DAS 07 9-83
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								16/01/24
110		0.00							DAS 07 9-83
110									
Small Fab	Memo	0.02							
Small Fab	Assemble as per Dwg D4888-041								16/01/24
	1) Install air vents								
	2) Install lights								
	3) Install rheostats								
	4) Install wiring harness								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 140867

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140867

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Item ID: D4888-041L02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Dome Light Air Vent Assembly, Black

Stop ***NS2***

Start Date: 1/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/29/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS 38 8-89
QC	Memo	0.00							
Quality Control									JAN 27 2016
130	Identify as per dwg & Stock Location: <u>SA</u>	0.00							
130									DAS 6 8-89
Packaging	Memo	0.00							JAN 27 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									MCS
QC	Memo	0.00							JAN 27 2016
Quality Control									

MCS JAN 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

January 21, 2016 11:06:20 AM

Page 1

Work Order ID: 140867

140867

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 1/21/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/09/13 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1 *D4886-1* Air Vent		Manufactured	No			100	Each	11.0000	2	2			DAS 6 9-89
**													

Location

Loc Qty

Loc Code

MF005

11

127803

11

D4888-1L02

Manufactured No

100

Each

2.0000

1

1

DAS
07
9-89

D4888-1L02

Dome Light Housing, Black

**

Location

Loc Qty

Loc Code

CA2

2

126932

2

D4897-041

Manufactured No

100

Each

0.0000

1

DAS
6
9-89

D4897-041

Dome Light Wiring

D4898-1

Manufactured No

100

Each

26.0000

12

12

**

D4898-1

Screw, Stainless Steel

Location

Loc Qty

Loc Code

MF006

26

127703

26

JAN 20 2016

Qty 5 In QC
Waiting for inspection

133482

Picklist Print

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Work Order ID: 140867

140867

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 1/21/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

D4906-1 Manufactured No

100 Each 11.0000 1 1

D4906-1

Knob

DAS

6

9-89

Location

Loc Qty

Loc Code

MF006

11

107708

1

128364

10

MS21042L06

Purchased No

100 Each 89.0000 12 12

MS21042L06

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

ST303

89

m133363

39

m133932

50

NAS1149F0663P

Purchased No

100 Each 103.0000 3 3

NAS1149F0663P

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

103

M132823

103

NAS1149FN632P

Purchased No

100 Each 139.0000 12 12

NAS1149FN632P

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

139

m129163

139

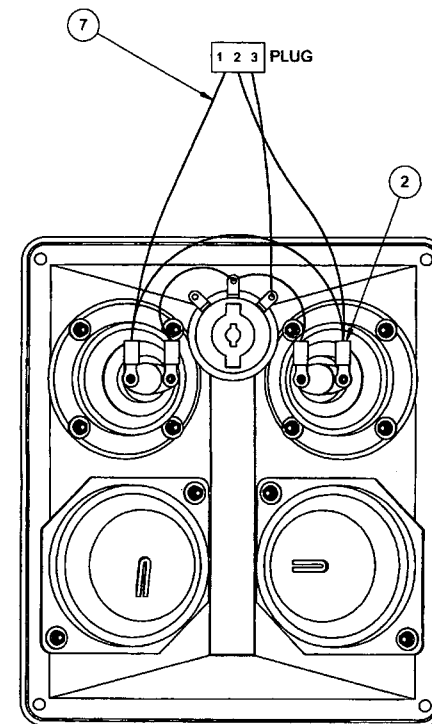
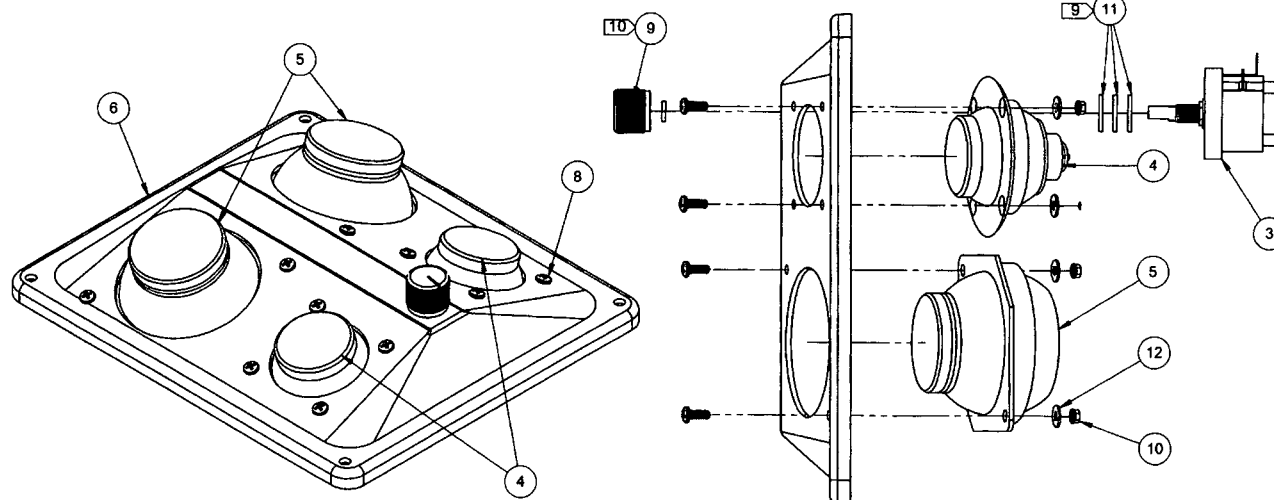
January 21, 2016 11:06:20 AM

Shop Packet Print

Page 2

JAN 26 2016

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4888-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4888-1	DOMELIGHT HOUSING
7	1	D4897-041	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER



D4888-041 DOME LIGHT AIR VENT ASSEMBLY

NOTES:

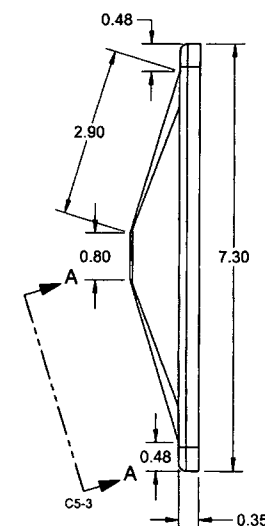
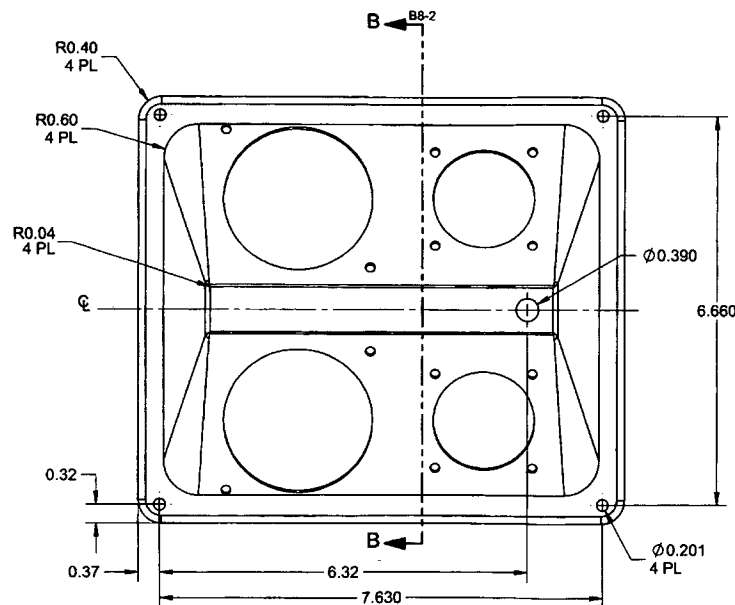
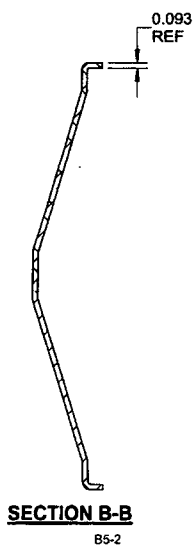
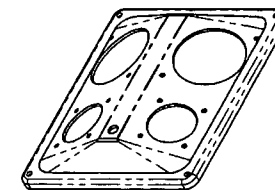
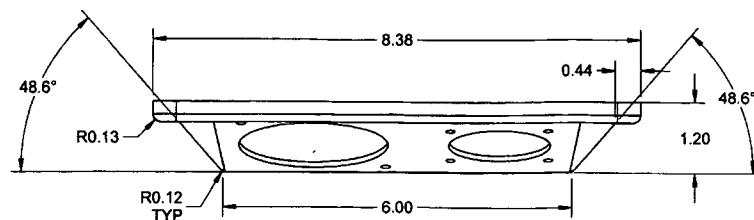
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) REPACES GENEVA P/N GA129-12 P112-L
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

20160121

RELEASED
2013-09-16

A	NEW ISSUE	13.07.11
REV.	DESCRIPTION	BY DATE
DESIGN	OS	
DRAWN	DE	
CHECKED	DE	
MFG. APPR.	DE	
APPROVED	DE	
DE APPR.	DE	
DATE	13.07.11	

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4888	REV. A
TITLE DOMELIGHT AIR VENT ASSY	SCALE NTS
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NOTES:

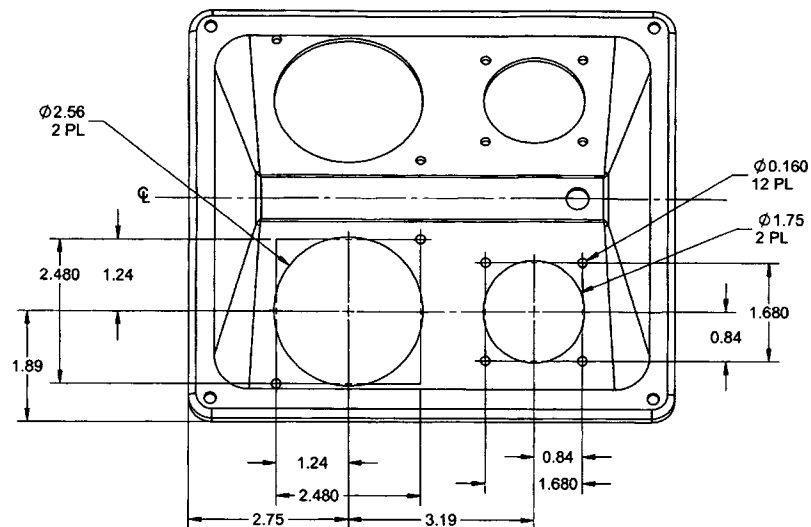
- 1) MATERIAL: SEE TABLE
- 2) TOOLING: THERMOFORM PER MOLD DT9932 PER QSI 022 TRIM PER DT9932
- 3) FINISH: N/A
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: 0.22 lbs
- 9) REPLACES GENEVA P/N GA129-7
- 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
- 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

D4888-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4888-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4888-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

DESIGN	CS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	CS		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4888	SHEET 2 OF 3
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DE APPR.	CS	DOME LIGHT AIR VENT ASSY	NTS
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2013-09-16



VIEW A-A
B2-2

RELEASED
2013-09-16

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CHECKED		DRAWING NO. D4888	REV. A
MFG. APPR.		SHEET 3 OF 3	
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